

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014383**Date Inspected:** 17-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Li Yang and Wu Zhi Cheng	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG Trial Assembly	

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Incident Report for Segment 8BW to 8CW

This Quality Assurance (QA) Inspector wrote an Incident Report for Excessive Gap between the T-Rib web to the Backing Bar and Notch and uneven surface preparation at T-Rib Web at Segment 8BW to 8CW between Panel Point (PP) 67 and PP 68 for more comprehensive details please refer the Incident Report # 04-0120F4_TL-15_B278_05-17-2010_T-Ribs at Transverse Splice Weld_8BW to 8CW between PP 67 and PP 68 Dated May 17, 2010. Please refer the attached pictures below for more comprehensive details.

Cope Hole Dimension Inspection

This QA Inspector performed dimension Inspection along with Caltrans QA Mr. Manikandan for the Cope Holes at Bottom Panel to Floor Beam and Side Panel to Floor Beam for the following locations.

ABF Report CWAHIR-10AW-01 at Panel Point (PP) 86, PP 87 and PP 88 work point W4 and W3.

Observed at PP 86 the smoothness of the Cope Hole of Side Panel to Floor Beam does not meets the requirement

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informed to the ZPMC and ABF QC to rectify that location and re-offer for inspection.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint SSD25-PP063-153/154 FL3 Partial Height Diaphragm. Welder is identified as 067079. ZPMC QC is identified as Feng Ya Jung. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint SSD25-PP063-61 FL3 Partial Height Diaphragm. Welder is identified as 067609. ZPMC QC is identified as Feng Ya Jung. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2233.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint SSD25-PP063-042 FL3 area at Partial Height Diaphragm. Welder is identified as 066401. ZPMC QC is identified as Feng Ya Jung. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2113.

Segment 8AE

This QA Inspector observed ZPMC welding personnel performing welding by Flux Cored Arc Welding (FCAW) for Side Panel to Bottom Panel connecting weld at work point E4. The weld joints are identified as Seg044B-046 and Seg044B-047. The welder is identified as 220069. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-345-FCAW-2G (2F)-Rep-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS. The welding was performed against Welding Repair Report B-WR12900.

Segment 7DE

This QA Inspector observed ZPMC welding personnel performing welding by Shielded Metal Arc Welding (SMAW). The weld joints are identified as Seg040-065. The welder is identified as 058087. In process SMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure i.e., WPS-B-P-2213-Tc-U4b-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint SSD25-PP063-132 FL3 Partial Height Diaphragm. Welder is

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identified as 066459. ZPMC QC is identified as Wang Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2113.

Segment 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint SSD25-PP063-136 FL3 Partial Height Diaphragm. Welder is identified as 067609. ZPMC QC is identified as Wang Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-B-U2-FCM-1.

Segment 8BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint CA049-006 Counter Weight Side Deck Panel to Edge Panel at Corner Assembly. Welder is identified as 067610. ZPMC QC is identified as Zhang Xing Ming. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Segment 7BW

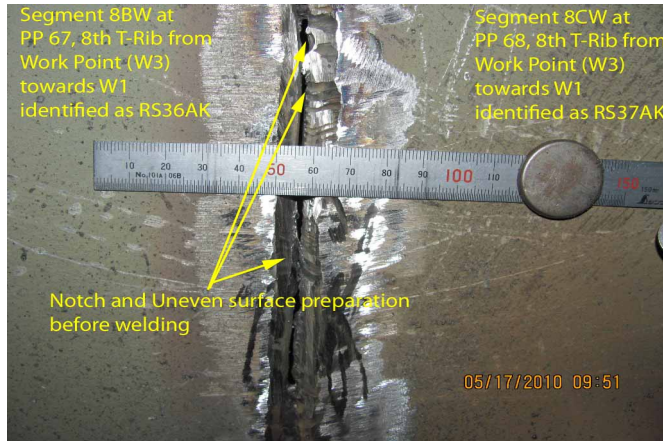
This Quality Assurance (QA) Inspector observed ZPMC qualified welder performing Shielded Metal Arc Welding (SMAW) welding was performed on weld joint OBW7N-003 Counter Weight Connecting Plate. Welder is identified as 069683. ZPMC QC is identified as Zhang Hai Tao. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer